

Work Order ID 122589

Tuesday, July 22, 2014 8:40:59 AM

122589

Page 1

Item ID: D3691-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Stud Assembly
 Start Date: 7/21/14 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 7/21/14 Req'd Qty: 5.00 ***5*** Customer:
 Reference:

Approvals: Process Plan: ML5 Date: 14-07-23 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3691	E ✓

100 Pick Kit 0.00

100

Packaging Memo 0.00
 Packaging

5X DAS NOV 19 2014
28
9-89

110 Small Fab 0.00

110

Small Fab Memo 0.00
 Small Fab

5X DAS NOV 19 2014
28
9-89

1-Align the pilot holes in mating parts. Drill out each hole using pilot drill and ream each hole using a step reamer. Clean and deburr all holes prior to assembly as per dwg. (SEE NOTE 8)

AFTER FINISH DRILLIN AND REAMING PARTS MUST STAY TOGETHER. DO NOT MIXE THEM UP

2-Assemble D3693-1 with D3691-1 Using Hysol EA934NA or MAGNOBOND 6398 adhesive between mating surfaces as per Dwg D3684

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 122589***122589***

Page 2

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Item ID: D3691-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Stud Assembly

Start Date: 7/21/14

Start Qty: 5.00

5

Cust Item ID:

Required Date: 7/21/14

Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

DAS
38
9-89

NOV 26 2014

130

Identify as per dwg & Stock Location: GA

0.00

130

Packaging

Memo

0.00

Packaging

5x DAS
28
9-89

NOV 27 2014

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

14/12/2 JH

D4-11-27

DQA: _____ Date: _____



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Picklist Print

Tuesday, July 22, 2014 8:40:53 AM

Page 1

Work Order ID: 122589

122589

Parent Item: D3691-041

D3691-041

Parent Item Name: Stud Assembly

Start Date: 7/21/14

Required Date: 7/21/14

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A 13.01.24 PER ECN12-693 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3691-1 *D3691-1* Stud		Manufactured	No				Each	8.0000		5			
									**			DAS 28 9-89	NOV 19 2014
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				st510			8			122754X3			
				112605			8			2X			
D3693-1 *D3693-1* Rod End Bearing		Manufactured	No				Each	6.0000		5			
									**			DAS 28 9-89	
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				GA			6			112185X4			
				101467			6			120733X4			
										1X			
HL32PB8-14 *HI 32PB8-14* Pin		Purchased	No				Each	212.0000		10			
									**			DAS 28 9-89	
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST262			212						
				125436			12						
				m128179			100			10X			
				m128454			100						
HL86-8 *HI 86-8* Collar		Purchased	No				Each	142.0000		10			
									**			DAS 28 9-89	
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST284			142						
				m126267			42						
				m127815			100			10X			

DQA: _____ Date: _____



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